



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4918-3
Job Sheet 167597



Part No: D4918-3

Job Qty: 4 ea

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/3/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/23/17	0.00	0.00	Start Up Waterjet1		<i>De</i>
100	Waterjet	4 pcs		11/23/17	0.00	0.70	Waterjet1		<i>De</i>
110	QC	4 pcs		11/23/17	0.00	0.00	QC2		<i>De</i> DAS
120	QC	4 pcs		11/23/17	0.00	0.00	QC8		<i>De</i> 38
130	Brake NC	4 pcs		11/23/17	0.00	0.23	Brake NC 1		<i>De</i> DAS 9-06
140	QC	4 pcs		11/23/17	0.00	0.00	QC5		<i>De</i> 38
150	SprayPaint	4 pcs		11/24/17	0.00	0.13	Spray Paint		<i>De</i> DEC 13 2017
160	QC	4 pcs		11/24/17	0.00	0.00	QC5 QC3		<i>De</i> 17-12-19
170	Packaging	4 pcs		11/24/17	0.00	0.00	Packaging3		<i>De</i>
180	QC21-SA	4 Ea		11/24/17	0.00	0.00	QC21		<i>De</i>

Part Op 110 - QC2- Inspect parts off machine FAI/FAIB

Descriptions: 120 - QC8- Inspect parts - second check

140 - QC5- Inspect part completeness to step on W/O

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location: **FP-002**

180 - QC21- Final Inspection - Work Order Release

Rockguard 138637

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S20GA	3	200	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.188Inches + 0.005 - 0.001	0.193 0.187		
2	Wearplate	0.300Inches ± 0.010	0.310 0.290		
3	Wearplate	0.300Inches ± 0.010	0.310 0.290		
4	Wearplate	2.063Inches ± 0.010	2.073 2.053		
5	Wearplate	2.813Inches ± 0.010	2.823 2.803		
6	Wearplate	33.750Inches ± 0.010	33.760 33.740		

DART
AEROSPACE
S015516



Wearplate Center Fwd

PART NO: D4918-3

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/29/17

Job No: 167597

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

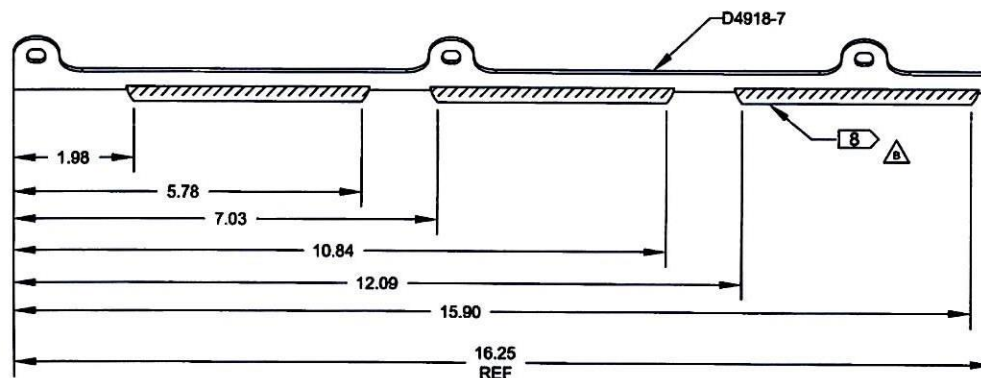
www.dartaerospace.com

7	Wearplate	5.625Inches $\pm$ 0.010	5.635 5.615
8	Wearplate	37.130Inches $\pm$ 0.030	37.160 37.100
9	Wearplate	0.040Inches $\pm$ 0.010	0.050 0.030

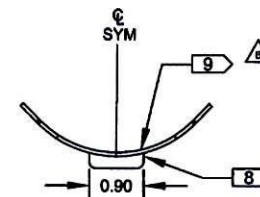
Plex 11/3/17 8:32 AM dart.Michaud-Febrille.Victoria



ITEM	QTY -047	P/N	DESCRIPTION
	X	D4918-047	WEARPLATE
1	1	D4918-7	WEARPLATE
2	A/R	8259 OR 2059B	HARDCOAT (AUTOMATED) HARDCOAT (MANUAL)



D4918-047 WEARPLATE
MAKE FROM D4918-7



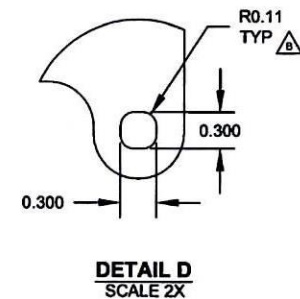
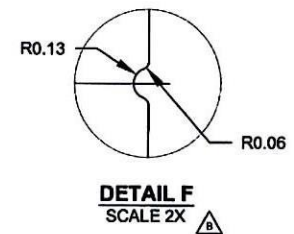
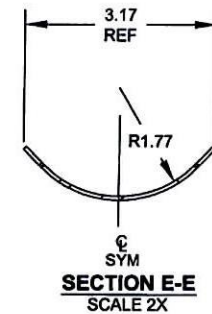
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4918-047" PER QSI 044 6.1
- 7) WEIGHT: 2.18 lbs
- 8) APPLY 2 LAYERS OF HARD SURFACING WELD BEAD 0.19 TO 0.25 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY 2 LAYERS OF HARD SURFACING WELD BEAD 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK PER QSI 005 4.9

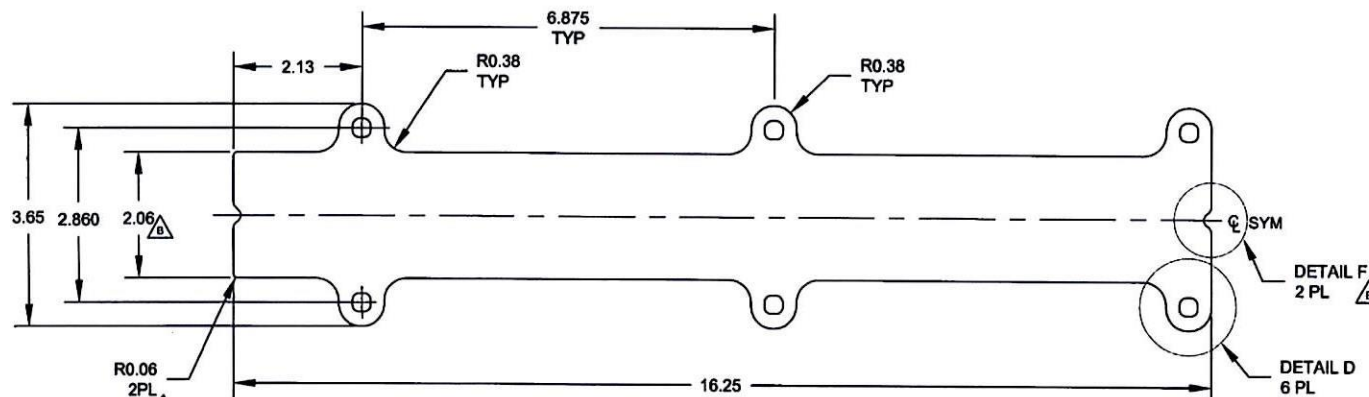
RELEASED
2017-04-12

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	SAD	EUGENE, OR	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4918	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
DATE	17.02.14	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

D4918-7 WEARPLATE
MAKE FROM D4918-7F



D4918-7F WEARPLATE
FLAT PATTERN



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED PER MIL-S-5059 OR AMS 5513
OR AMS 5524 OR ASTM A240 OR ASME SA240
16 GAUGE (0.063 THICK)
(REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.66 lbs

RELEASED
2017-04-12

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	SAD	EUGENE, OR	
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐								
Date: <u>17/12/13</u>	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval DAS 12 9.89 <u>17/12/13</u>						
Description Work Order Deviation Applying Axalta cohesion promoter is time consuming. Testing by ENG. indicated that Axalta provides no measurable benefit. Both treated & untreated wccplates held equally well after several days of submersion submersion.		Disposition Acceptable to <u>not</u> use Axalta cohesion promoter on wccplates. AS DEC 13 2017		Completed By DAS 12 9.89 <u>17/12/13</u> Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval						
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; border-right: 1px solid black;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; border-right: 1px solid black;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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